

Work Order ID 51387

August 20, 2009 3:35:45 PM



Page 1

Item ID: D3195-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket Assembly

Start Date: 21/08/2009 Start Qty: 8.00

Cust Item ID:

Required Date: 27/08/2009 Req'd Qty: 8.00

Customer:

Reference:

See 09.08.20

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3195	Rev A								

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (0.75" x 2.00") x 3.60" long

8

0

H.A 09/08/20

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3195-1 as per Folio FA334 and Dwg D3195 Identify as D3195-1
1□Deburr

H.A 09/08/20

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

H.A 09/08/20

Work Order ID 51387

August 20, 2009 3:35:45 PM



Page 2

Item ID: D3195-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket Assembly

Start Date: 21/08/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 27/08/2009 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>m= 09/08/21</i>		<u>8</u>	<u>0</u>		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>(x8)</u>	<u>mo 09/08/24</u>		
150 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: <u>7:30 AM</u> <u>8:00 AM</u> FINISH TIME: <u>5:20 PM</u>	0.00 0.00		<i>=> JW 09/08/26</i>		<u>x8</u>	<u>0</u>		

Work Order ID 51387

August 20, 2009 3:35:45 PM



Page 3

Item ID: D3195-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket Assembly

Start Date: 21/08/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 27/08/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BR 09-08-26

8

170



Small Fab

Small Fab

Small Fab

Memo

1-Lightly Sand bonding surface 2-Bond D3195-5 into D3195-1 as per Dwg
D3195 A/RContact Cement 17109107

0.00

0.00

ES 09/08/27 8

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2) 8 09/08/27

78

Work Order ID 51387

August 20, 2009 3:35:45 PM



Page 4

Item ID: D3195-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket Assembly

Start Date: 21/08/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 27/08/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 246A

0.00



Packaging

Memo

0.00

Packaging

9/8/28 (8x) SP

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/31 AGBR 09-8-28 (8)

Picklist Print

Page 1

August 20, 2009 3:35:44 PM

Work Order ID: 51387

Parent Item: D3195-041RevA

Parent Item Name: Bracket Assembly



Comments:

Start Date: 21/08/2009

Required Date: 27/08/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3195-5RevA		Manufactured	No			100	Each	5.0000	8.0000		25/09/08/27	
<div>   </div>												
Pad												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

31533

5

M6061T6B0.750X02.00

Purchased

No

170

f

53.0000

2.5263

0



6061-T6 Bar .750 x 2.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

53

100742

11.5

111448

40

18571

1.5

Y.A 09/08/20

B51570 (37)

5

6

2.5263

DART AEROSPACE LTD		Work Order:	51387
Description: Bracket		Part Number:	D3195-1
Inspection Dwg: D3195 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.265	+/-0.010	1.265	✓			
0.242	+/-0.010	0.242	✓			
1.084	+/-0.010	1.084	✓			
R0.200	+/-0.010	R0.200	✓			
R0.377	+/-0.010	R0.377	✓			
Ø0.277	+0.005/-0.000	Ø0.280	✓			
2.677	+/-0.005	2.676	✓			
3.432	+/-0.010	3.432	✓			
0.754	+/-0.010	0.753	✓			
1.387	+/-0.010	1.387	✓			
0.500	+/-0.010	0.500	✓			
0.250	+/-0.005	0.251	✓			
1.754	+/-0.010	1.754	✓			
Ø0.191	+0.005/-0.000	Ø0.1935	✓			

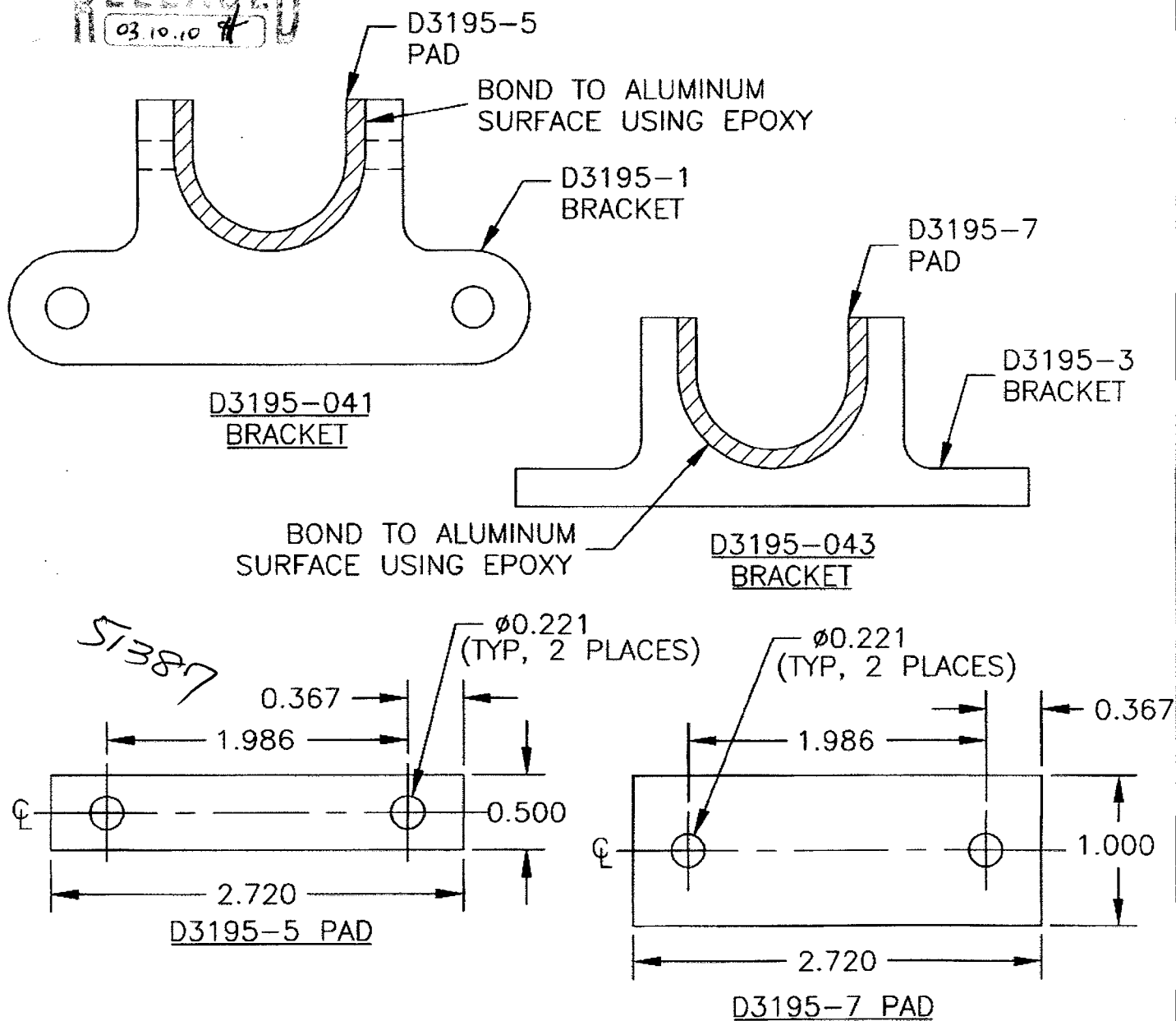
Measured by:	G.A	Audited by:	mmj	Prototype Approval:	N/A
Date:	09/08/20	Date:	09/08/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-13)	KJ/RF	PF



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1
A	03.06.23	NEW ISSUE	

RELEASED
03.10.10 *#*



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

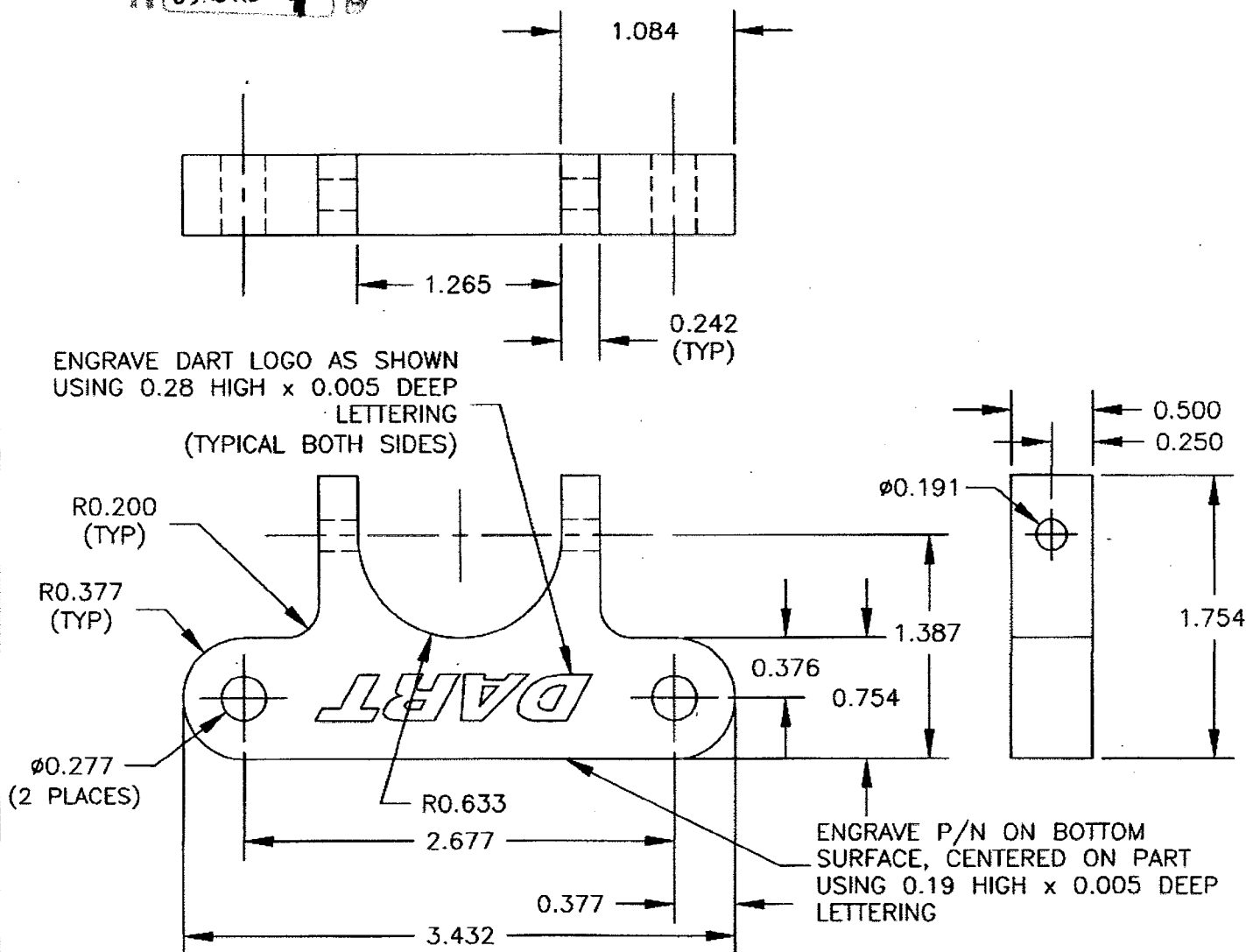
Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1

RELEASED
03.10.10



D3195-1 BRACKET

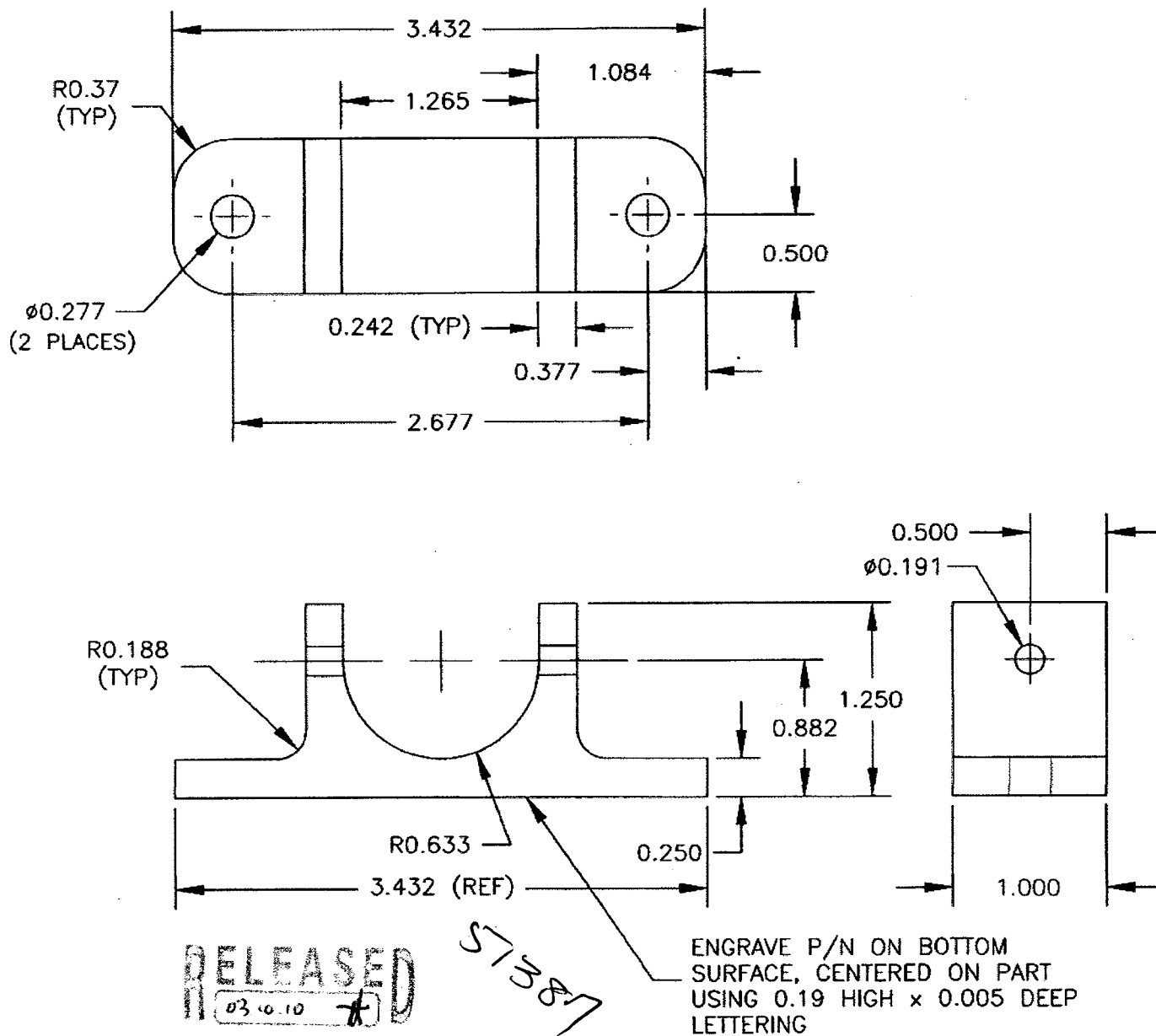
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1

**D3195-3 BRACKET**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.